

Date: Friday, 12/7/2007 10:20:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, INBOARD, LS, 206
Job Number : 36185	
Estimate Number : 10820	
P.O. Number :	Part Number : D26661
This Issue : 12/7/2007 S.O. No. :	Drawing Number : D2666 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 34859	Material :
Written By :	Due Date : 12/31/2007 Qty: 12 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.12.07	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC	
Est Rev:D As per Rev D 07-03-19 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 2X6X6.25
 Issue material from stock:
 Cut Size 2.0 x 6.25 X 6.0
 Grain Along Long 6.0 Length

Batch No: B34872 DSP 08/02/04

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Fixturing Inspection last completed on 36185 by DSP
 3-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 8-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 9- Deburr

S.F 08/02/05
DSP 08/02/04

(12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

S.F 08/02/05
DSP 08/02/04

(12)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 08/02/04 / S.F 08/02/05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:20:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 36185

Part Number: D26661

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08/02/06

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

M-L

08/02/06

(12X)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

M106379

FX 08/02/07

(12)

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

M-L

08/02/07

(12X)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 426

AS 08/02/07

(12)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

2008/02/08

(12)

Job Completion



2008/2/07

(12)

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36185
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.137	.137	.137	.138		
B	0.100	0.140		0.127	.127	.127	.128		
C	2.470	2.510		2.494	.494	.494	.495		
D	0.100	0.180		0.140	.140	.140	.140		
E	0.210	0.230		0.220	.222	.225	.225		
F	1.313	1.343		1.325	1.325	1.325	1.328		
G	0.240	0.260		0.254	.254	.254	.254		
H	0.615	0.685		0.670	.670	.670	.670		
I	1.125	1.145		0.1415	.141	.142	.142		
J	0.990	1.010		1.008	1.008	1.006	1.006		
K	0.235	0.240		0.237	.237	.238	.239		
L	0.510	0.515		0.511	.511	.511	.511		
M	0.100	0.120		0.107	.107	.108	.108		
N	1.565	1.585		1.573	1.573	1.572	1.572		
O	5.990	6.010		0.1000	6.000	6.002	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.499	2.500	2.500	2.500		
R	0.490	0.510		0.500	.500	.501	.501		
S	0.313	0.318		0.315	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.3615	1.361	1.361	1.361		
V	0.315	0.322		0.320	.320	.320	.320		
W	0.540	0.560		0.554	.554	.555	.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.259	.259	.259	.259		
Z	0.178	0.198		0.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: **DJP**
Date: **08/02/04** / **08/02/05**

Audited by: **J.L**
Date: **08/02/06**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	36185
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.135	.135	.135	.135		
B	0.100	0.140		.125	.127	.127	.127		
C	2.470	2.510		2.497	2.497	2.497	2.497		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.225	.225	.227	.225		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.240	0.260		.254	.254	.255	.255		
H	0.615	0.685		.670	.670	.670	.670		
I	1.125	1.145		.142	.142	.142	.142		
J	0.990	1.010		1.007	1.005	1.001	1.001		
K	0.235	0.240		.239	.239	.239	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.108	.108	.108	.108		
N	1.565	1.585		1.572	1.570	1.570	1.570		
O	5.990	6.010		6.006	6.005	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.501	2.501	2.500	2.500		
R	0.490	0.510		.502	.502	.502	.502		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.360	1.360	1.360		
V	0.315	0.322		.318	.318	.318	.318		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.670	1.670	1.670	1.670		
Y	0.257	0.262		.260	.260	.260	.260		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: RF
Date: 08/02/05

Audited by: J.L
Date: 08/02/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	36185
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.135	.135	.135	.135		
B	0.100	0.140		.127	.127	.127	.126		
C	2.470	2.510		2.500	2.500	2.500	2.500		
D	0.100	0.180		.140	.140	.140	.140		
E	0.210	0.230		.225	.225	.225	.225		
F	1.313	1.343		1.328	1.328	1.328	1.328		
G	0.240	0.260		.254	.254	.254	.255		
H	0.615	0.685		.670	.670	.670	.670		
I	1.125	1.145		.142	.142	.142	.142		
J	0.990	1.010		1.007	1.007	1.006	1.005		
K	0.235	0.240		.238	.238	.238	.238		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.108	.108	.108	.108		
N	1.565	1.585		1.570	1.570	1.570	1.570		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.502	.502	.502	.502		
S	0.313	0.318		.318	.318	.318	.318		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.360	1.360	1.360		
V	0.315	0.322		.318	.318	.318	.318		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	LF
Date:	08/02/05

Audited by:	J.L
Date:	08/02/06

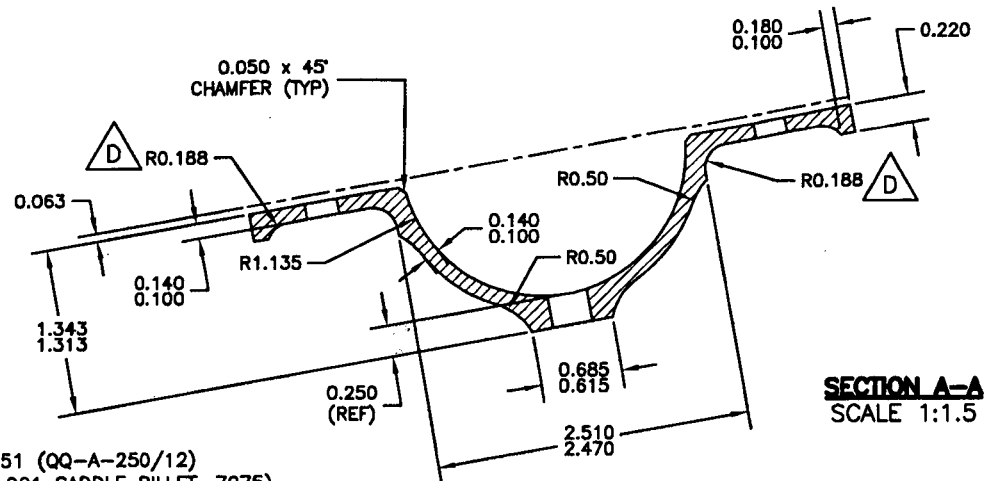
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

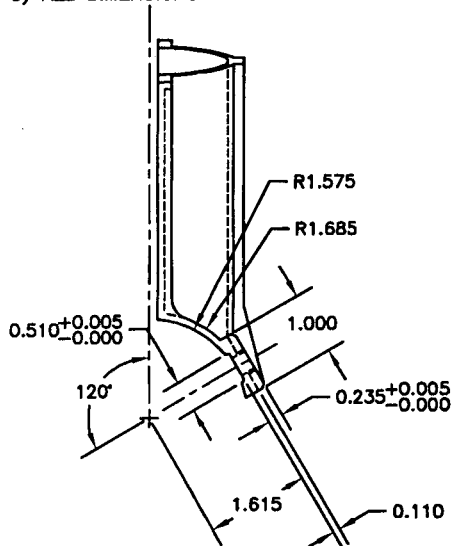
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07.02.12 #

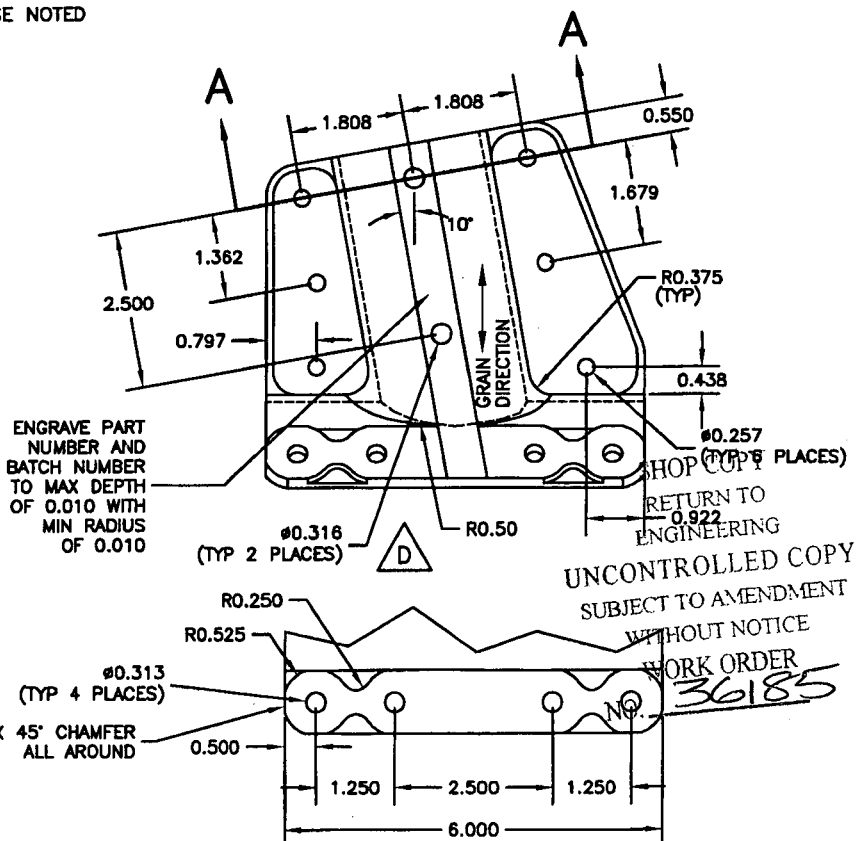


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



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